

Work Order ID 147222

June 07, 2016 3:17:43 PM

147222

Shipping June 10.

Page 1

Item ID: D4887-041L02

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Dome Light Air Vent Assembly, Black

Stop

NS2

Start Date: 6/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SA

Date: 6/7/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4887	A

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

X1

DAS

07

9-89

12/06/08

110

0.00

110

Small Fab

Memo

0.13

Small Fab

Assemble as per Dwg D4887-041

X1

DAS

07

9-89

12/06/08

- 1) Install air vents
- 2) Install lights
- 3) Install rheostats
- 4) Install wiring harness

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 147222***147222***

Page 2

June 07, 2016 3:17:43 PM

Item ID: D4887-041L02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dome Light Air Vent Assembly, Black

Start Date: 6/8/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo

0.00

Quality Control

① 16-06-09 PS

130 Identify as per dwg & Stock Location: A 0.00***130***

Packaging

Memo

0.00

Packaging

1 JUN 09 2016

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.02

Quality Control

16/06/15 RRAV / JG

MLJ JUN 10 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

June 07, 2016 3:17:47 PM

Page 1

Work Order ID: 147222

147222

Parent Item: D4887-041L02

D4887-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 6/8/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 13/09/11 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1		Manufactured	No			100	Each	7.0000	2	2			
D4886-1									**				DAS 6 9-89
Air Vent													

Location	Loc Qty	Loc Code
MF005	7	
127803	3	
141981	4	

D4887-1L02		Manufactured	No			100	Each	2.0000	1	1			DAS 6 9-89
D4887-1L02									**				
Dome Light Housing, Black													

Location	Loc Qty	Loc Code
MF001	2	
119616	1	
123091	1	

D4897-043		Manufactured	No			100	Each	7.0000	1	1			DAS 07 9-89
D4897-043									**				
Dome Light Wiring													

Location	Loc Qty	Loc Code
MF006	7	
138514	7	

D4898-1		Manufactured	No			100	Each	78.0000	12	12			DAS 6 9-89
D4898-1									**				
Screw, Stainless Steel													

Location	Loc Qty	Loc Code
MF006	78	
141124	78	

JUN 8 0 2016

Picklist Print

June 07, 2016 3:17:47 PM

Page 2

Work Order ID: 147222

147222

Parent Item: D4887-041L02

D4887-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 6/8/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

D4906-1 Manufactured No

100 Each 7.0000 2 2

D4906-1

Knob

DAS
6
9-89

Location

Loc Qty

Loc Code

MF006

7

128364

7

MS21042L06 Purchased No

100 Each 171.0000 12 12

MS21042L06

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

ST303

171

m134474

21

m134537

100

m134962

50

NAS1149F0663P Purchased No

100 Each 200.0000 6 6

NAS1149F0663P

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

ST261

200

M134365

200

NAS1149FN632P Purchased No

100 Each 91.0000 12 12

NAS1149FN632P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST263

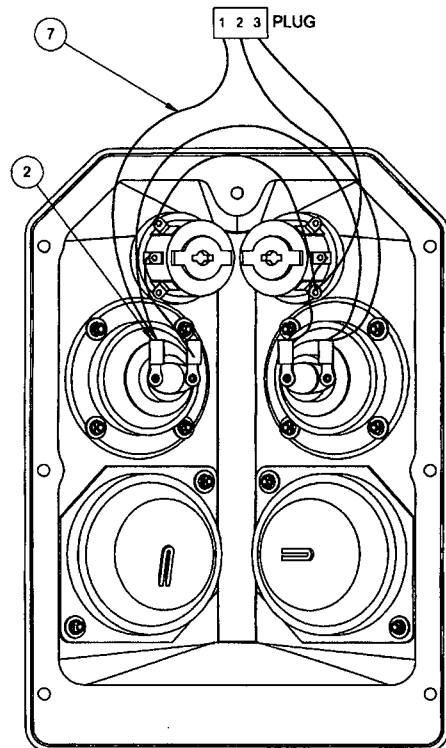
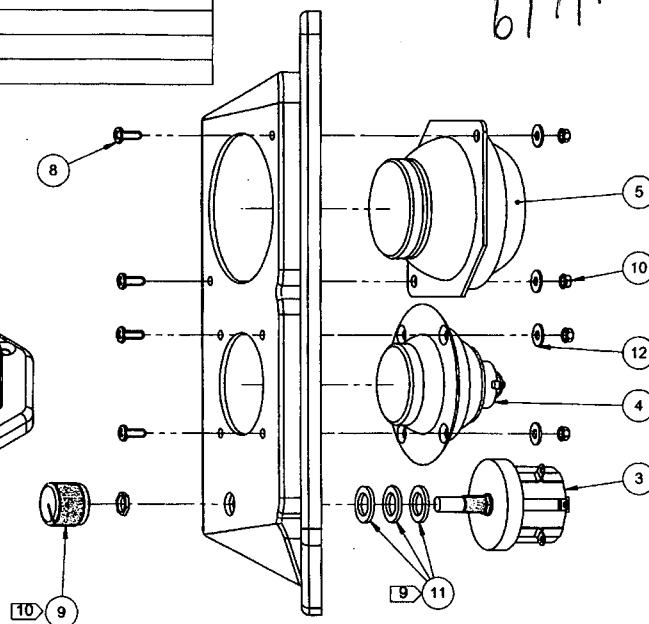
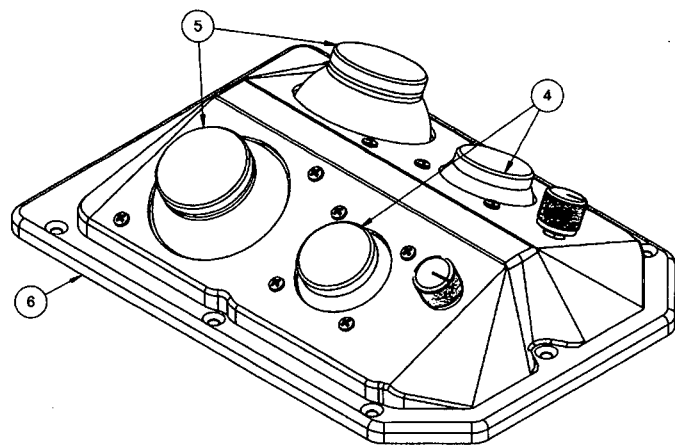
91

m129163

91

JUN 08 2016

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4887-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-043)
3	2	D4864-3 (REF)	RHEOSTAT (PART OF D4897-043)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-043)
5	2	D4886-1	AIR VENT
6	1	D4887-1	DOMELIGHT HOUSING
7	1	D4897-043	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	2	D4906-1	KNOB
10	12	MS21042L06	NUT
11	6	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER



147 722
SH
6/7/16

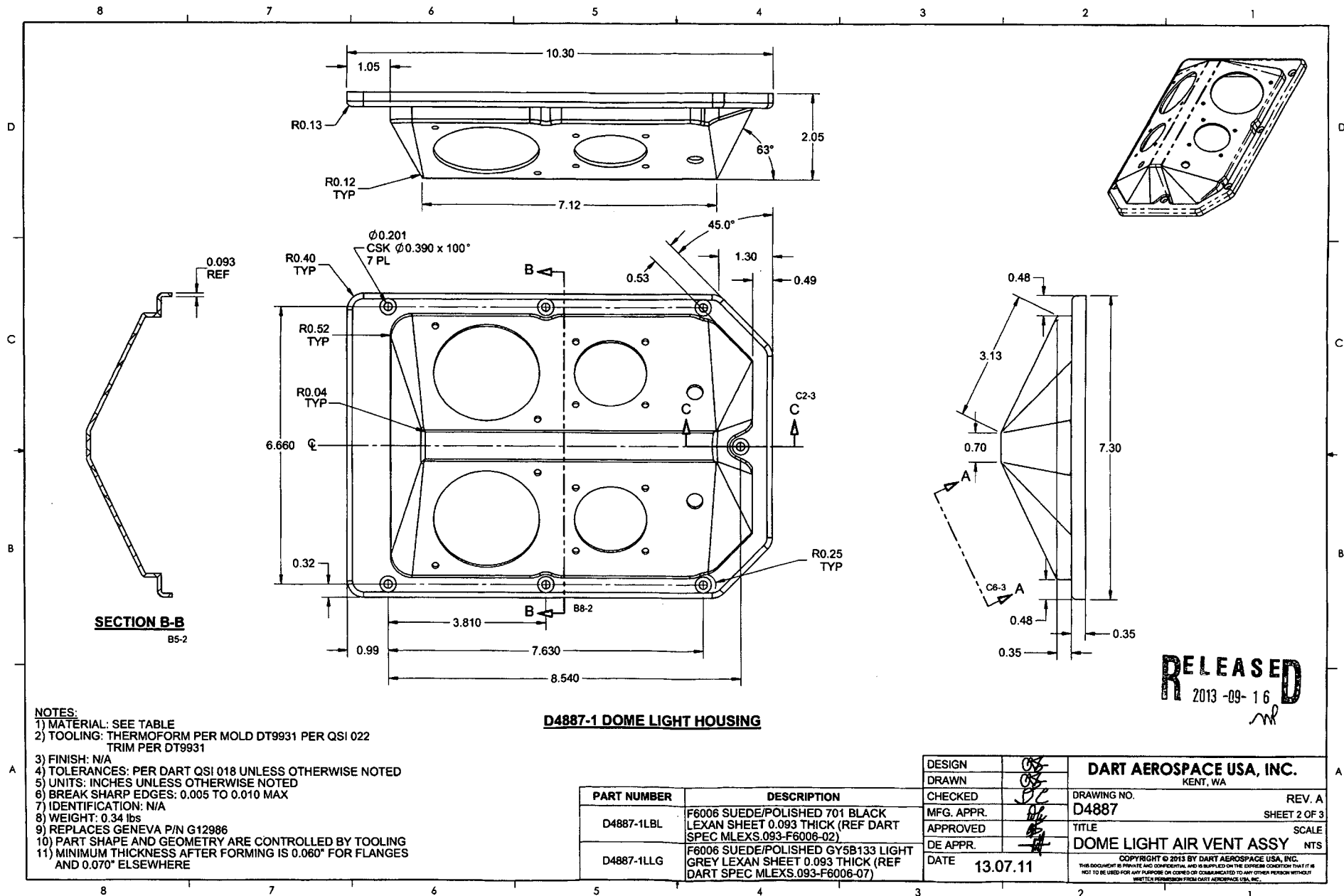
RELEASED
2013-09-16

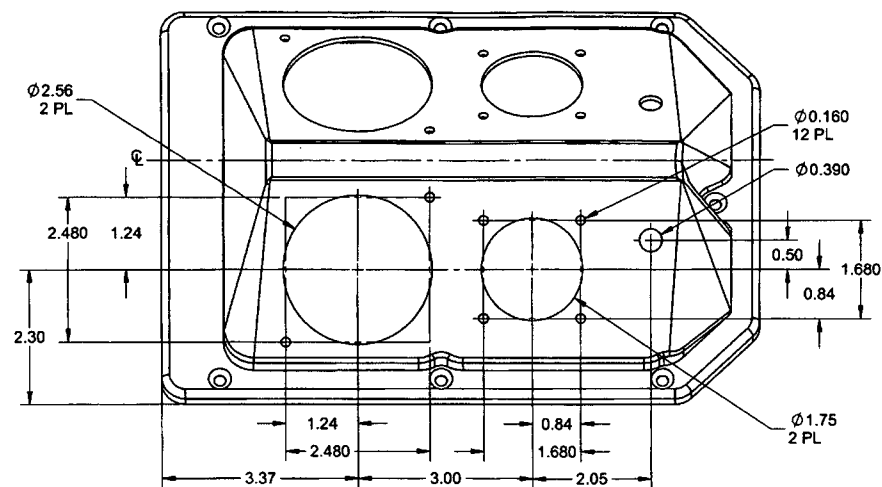
D4887-041 DOME LIGHT AIR VENT ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.43 lbs
 - 8) REPLACES GENEVA P/N G12984 P112-XL
 - 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
 - 10) NUT INCLUDED WITH RHEOSTAT

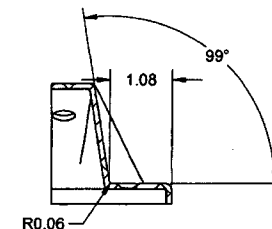
A NEW ISSUE		08	13.07.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4887	REV. A SHEET 1 OF 3
TITLE DOME LIGHT AIR VENT ASSY	SCALE NTS
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VIEW A-A B3-2



SECTION C-C
B4-2

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MFG. APPR.	<i>HL</i>	D4887	SHEET 3 OF 3
APPROVED	<i>HL</i>	TITLE	SCALE
DE APPR.	<i>HL</i>	DOMELIGHT AIR VENT ASSY	NTS
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